

Date: Tuesday, 07/04/2009 10:19:16 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR WEDGE
Job Number : 46964	
Estimate Number : 12110	
P.O. Number :	Part Number : D32001
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3200 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 46519	Material :
Written By :	Due Date : 20/04/2009 Qty: 30 Um: Each
Checked & Approved By : <u>JLD 07.04.07</u>	
Comment : Est Rev:A Removed from 9 Digit 06-01-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.0525 sf(s)/Unit Total : 1.5750 sf(s)

UHMW 1" Black

Material: Black UHMW 0.95" or 1.00" thick

Use bearpaw scrap material

(MUHMWB10)

Identify for D3200-1

Batch: 4108013

07/04/15

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank: 2.700" x 2.700

07/04/15

53 ps

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine D3200-1 as per Folio FA337 and Dwg D3200

2-Deburr

J.F. / 07/04/16

(52)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / 07/04/16

(52)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3200-1 PAR #: N/A Fault Category: Prod/Machined Parts NCR: (Yes) No DQA: D Date: 09/04/16
D412-698-015
Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/16

NCR: <u>46964</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/16</u>	<u>3.0</u>	<u>1 part Scrap</u> <u>Part was installed</u> <u>incorrectly in vise. opposite</u> <u>side. operator error.</u>	<u>[Signature]</u> <u>09/04/16</u>	<u>1 Scrap No Replace</u>	<u>[Signature]</u> <u>09/04/16</u>	<u>[Signature]</u> <u>09/04/16</u>	<u>[Signature]</u> <u>09/04/16</u>	<u>[Signature]</u> <u>09/04/16</u>

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:19:16 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR WEDGE

Job Number: 46964

Part Number: D32001

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



52

Comment: SECOND CHECK

mf 09/04/16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5776

8 09/04/16 52

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/04/17

Job Completion



0209/04/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

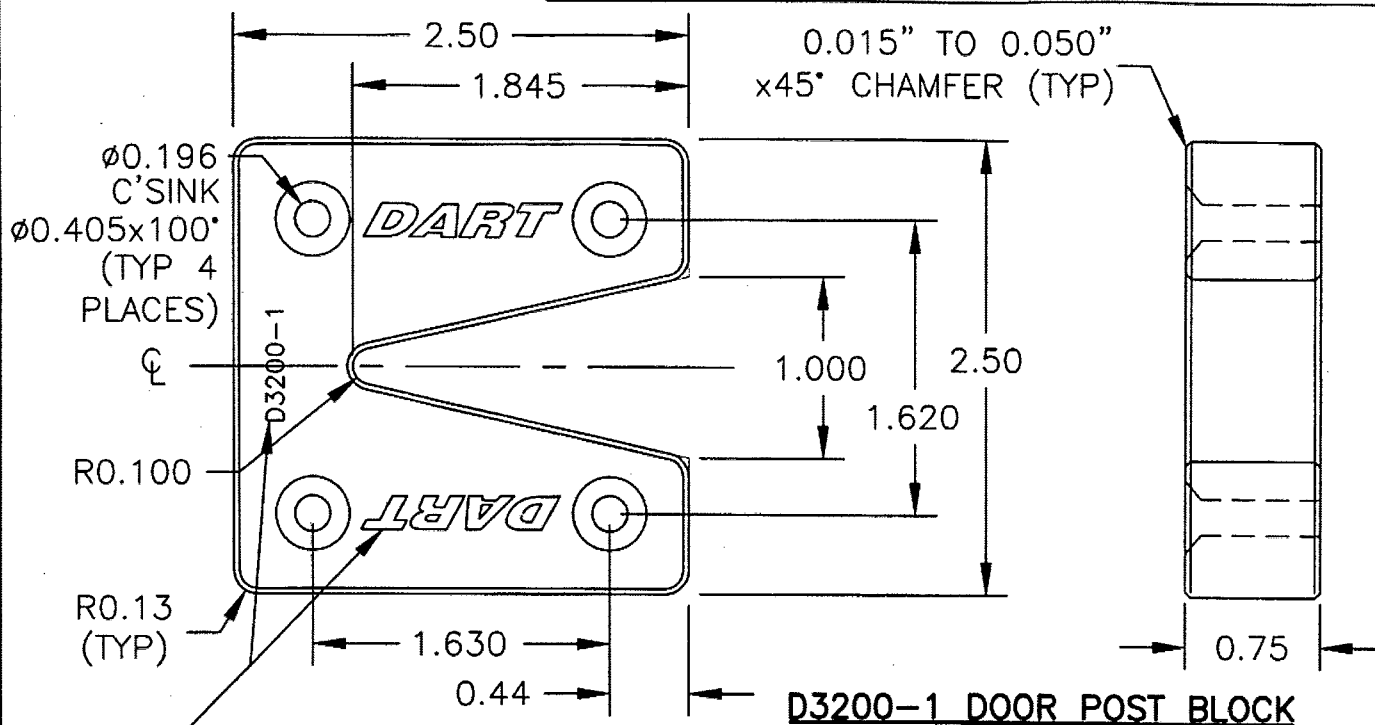
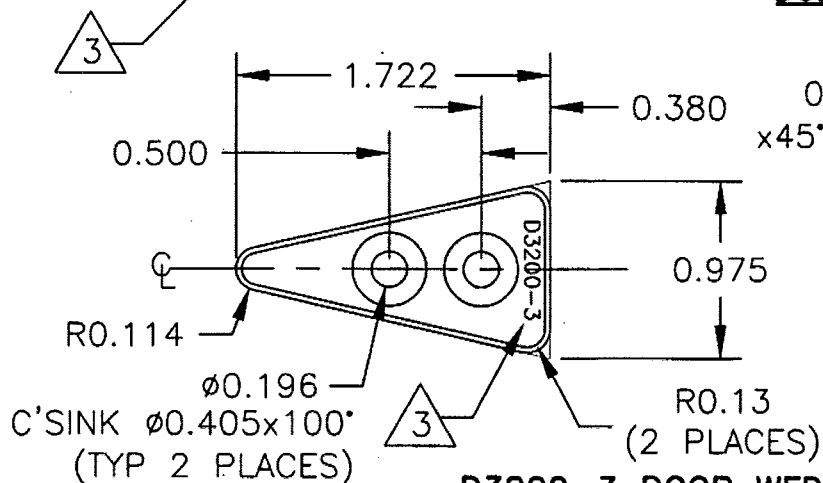
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06	TITLE DOOR WEDGE		SCALE 1:1
A	03.08.06	NEW ISSUE	

**D3200-1 DOOR POST BLOCK****D3200-3 DOOR WEDGE****D3200-1/-3**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.02

0.75
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WORK ORDER
NO. 40964

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